

Date: Tuesday, 7/1/2008 10:46:37 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EXTRUSION 'I' BEAM TUBE 4"
Job Number : 40150	
Estimate Number : 10154	
P.O. Number :	Part Number : D25001190
This Issue : 7/1/2008 S.O. No. :	Drawing Number : D2500 UNDER REVIEW <i>OK 08.07.01</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : G
Previous Run : 37544	Material :
Written By :	Due Date : 7/30/2008 Qty: 80 Um: Each
Checked & Approved By : <i>08.07.01</i>	
Comment : Est: G 02.09.05 Added DSK 066 KJ/RF	
est H 07.07.06 rev G dwg EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *6672**C 08/07/02 (80)*

a) Extrude as per Dwg D2500

b) Material: 6061-T6 (QQ-A-200/8) *OK ASTM B221 08.07.01*

c) Minimum yield tensile strength = 35 ksi

d) Minimum ultimate tensile strength = 38 ksi

e) Minimum elongation = 8%

f) Order at 190" long

g) Bon L Canada Inc. tool # 897105

h) To be packed per DSK 066

i) Pull test to ASTM standard B221 required.

j) Material certification is required

2.0

D25001190P

Ext'n - 'I' Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s)
 EXTRUSION 'I' BEAM TUBE 4"

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

08/07/17
08/07/17
78
HALL 63 LG 15 78 TOTAL
78

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per Dwg D2500

Check Pull test per Dwg D2500 for compliance page attached.

08/07/17
78
counted

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 10:46:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EXTRUSION 'I' BEAM TUBE 4"

Job Number: 40150

Part Number: D25001190

Job Number:



Seq. #:

Machine Or Operation:

Description :

Check hardness with Webster tester

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

HALL 001-63 L.G-15 = TOTAL 20 Am

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-02-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2500	REV. G SHEET 1 OF 3
DATE 07.04.17		TITLE EXTRUSION	SCALE NTS
A	96.03.19	NEW ISSUE	
B	96.03.24	CHANGE INTERNAL WEB	
C	96.04.26	ADD D2500-3 WEB	
D	96.10.07	ADD MATERIAL PROPERTIES	
E	96.10.24	CHANGE MATERIAL TEMPER	
F	97.09.29	CHANGE MAT. TO 6061-T6	
G	07.04.17	ADD NOTES 3,5,6	

RELEASED
07.06.28 *[Signature]*

UNDER REVIEW

08.04.02 *[Signature]*
FOR REV. H

- MATERIAL: 6061-T6 (QQ-A-200/8% *OR ASTM B221*) *CP* 08.07.01
MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO
ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY
TO ENSURE THAT THE BATCH MEETS THE ABOVE
MINIMUM MECHANICAL PROPERTIES
- BREAK ALL SHARP CORNERS 0.010 MAX
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH (EX. D2500-1-190 IS 190" LONG)
D2500-1 EXTRUSION MANUFACTURED FROM:
 - BON L DIE # 897015 -> PREFERRED
 - CARADON MIDEAST DIE # PAH-28030
 - CARADON MTL DIE # MH-18868
- FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG)
D2500-3 EXTRUSION MANUFACTURED FROM:
 - CARADON INDALEX DIE # MS-18867

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NO. 40150

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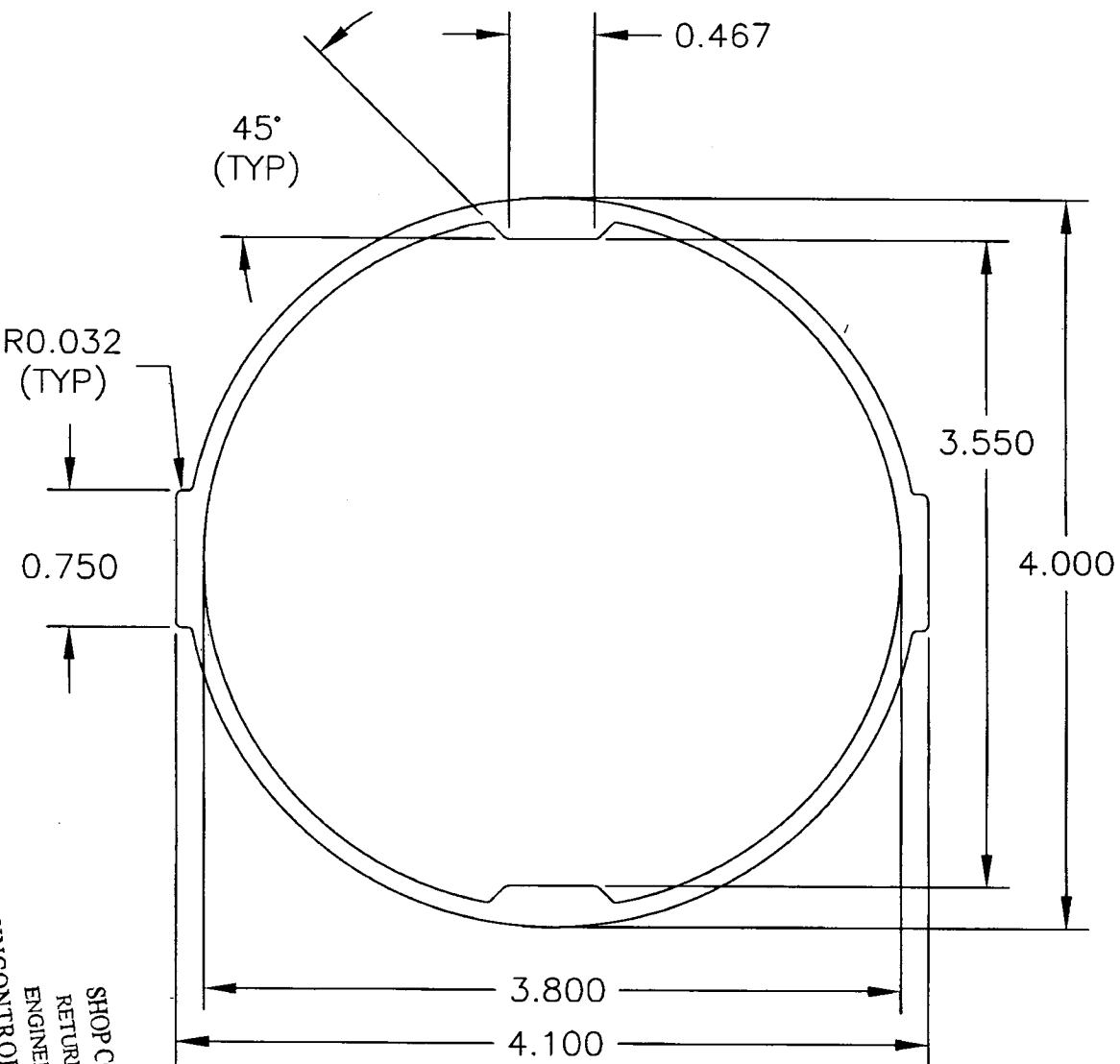
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	REV. G
DATE	07.04.17	DRAWING NO.	D2500	SHEET 2 OF 3
		TITLE	EXTRUSION	SCALE
				1:1

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07.06.18 *[Signature]*

UNDER REVIEW
08.04.02 *[Signature]*
FOR REV. H



D2500-1

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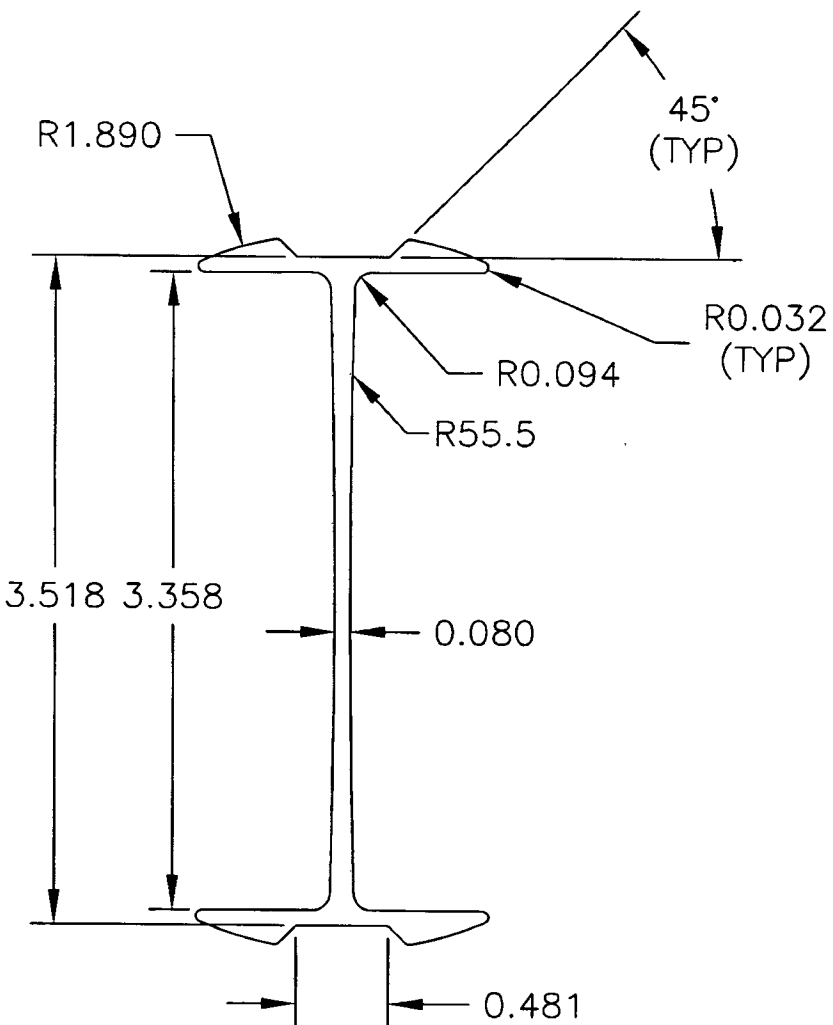
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2500	SHEET 3 OF 3
DATE	07.04.17	TITLE	EXTRUSION	SCALE	1:1

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07.06.28

UNDER REVIEW
08.04.02
FOR REV. H



D2500-3

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NO. 40150



INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

SHIPPING MANIFEST

ACCT# 00046024

MANIFEST DATE	07-15-08
MANIFEST NUMBER	643716
SALES ORDER NUMBER	33203

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE

TERMS / FREIGHT
O / P

SHIP TO DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200	SOLD TO / PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200
--	--

CREDIT REP HAMBROOK, PAU 905-508-3250	SALES REP
FIELD SALES REP Kutter A 450-435-6551	CUST SERVICE REP Burton D 905-427-2227

CUSTOMER ID 46024	ORDER DATE 07/02/08	CUSTOMER PO NUMBER 6672	JOB	BILL OF LADING NUMBER 08380474
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ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION	THIS SHIPMENT			UNIT	QUANTITY DUE
				CUSTOMER PART NUMBER	LENGTH	FABRICATION DESCRIPTION	NBR OF PKGS	GROSS POUNDS	NET QUANTITY		
					CUTTING TOLERANCE	SHIPPING TOLERANCE					
01	80	KG	0	DAA-897105-2	6061 /T6	MILL	3	1037	1003	KG	30
		M	0	D2500-1-190	190"	CERTIFICATE OF COMP			376.43	M	10
		PC	0		+5/16 "	(+010-010,0088-0072)			78	PC	2
					-0 "						
				LOT/TKT DETAIL:		33203010 / 279174	1	425	409		32 PC
						33203010 / 279175	1	306	297		23 PC
						33203010 / 279176	1	306	297		23 PC
78											

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Cert Date	Cert No	Sales Order	Page																												
07/15/08	179032	33203	1																												
Cust PO	B/L No	Lot	Date																												
6672	08380474	33203010	7/15/08																												
Sold To	46024	Ship To	46024																												
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7																													
Item No	Part No	Item Description	Cust Part																												
1.000	DAA-897105-2	190" Mill 6061 T6	D2500-1-190																												
Gross Weight	1037 KGS																														
Net Qty	1,003 KG	78 PC	376 M 3 PKG																												
Specification		Die Desc																													
AMS-QQ-A-200/8 & ASTM B221-06																															
<p>Mechanical Tests:</p> <table border="1"> <thead> <tr> <th>Test No.</th> <th>Tensile MPA / KSI</th> <th>Yield MPA / KSI</th> <th>%Elongation</th> <th>Conductivity</th> <th>Bend/Drift HREW</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>278.3 / 40.4</td> <td>252.7 / 36.7</td> <td>10.5</td> <td>.0</td> <td>94</td> </tr> </tbody> </table> <p>Chemical Analysis:</p> <table border="1"> <thead> <tr> <th>SI</th> <th>FE</th> <th>CU</th> <th>MN</th> <th>MG</th> <th>CR</th> <th>ZN</th> <th>TI</th> </tr> </thead> <tbody> <tr> <td>.64</td> <td>.26</td> <td>.27</td> <td>.06</td> <td>.88</td> <td>.06</td> <td>.03</td> <td>.02</td> </tr> </tbody> </table>				Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HREW	1	278.3 / 40.4	252.7 / 36.7	10.5	.0	94	SI	FE	CU	MN	MG	CR	ZN	TI	.64	.26	.27	.06	.88	.06	.03	.02
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<p>This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.</p> <p>Conchita Ko, QA Manager Signature Aluminum Canada Inc</p> <p style="text-align: right;"><i>Conchita Ko</i></p>																															